

Thursday, 6/21/2007 2:29:34 PM

Kin Johnston

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 33066
 Estimate Number : 11162
 P.O. Number : *N/A*
 This Issue : 6/21/2007 S.O. No. : *N/A*
 Part Number : D32641
 Drawing Number : D3264 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 7/12/2007 Qty: *5* Um: Each
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 32201
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 07.06.22
 Comment : Est A 04.09.02 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6B1250X04500 6061-T6 Bar 1.25" X 4.5"



Comment: Qty.: 0.5097 f(s)/Unit Total: 3.0580 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
 (M6061T6B1.250x04.500)
 Identify for D3264-1
 Batch: *M17655*

ml 07/08/28

4

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 4.500" x 1.250" x 5.700" long Bar

Bl 07.07.25

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA447 and Dwg D3264
 Identify as D3264-1
 Deburr

ml 07/08/28

4

(PTU)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*ml 07/08/28*

4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*SL 07/08/28**SL 07/08/28*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 33066

Part Number: D32641

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 01 08 25

(4)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

ml 01 09 02

(4)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/09/04

4X

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock Location:

07/09/04

(4)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/04

Job Completion:



W 07.09.04



| | | | |
|------------------------------|--|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 33066 |
| Description: Bracket | | Part Number: | D3264-1 |
| Inspection Dwg: D3264 Rev: A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.687 | +/-0.010 | 0.684 | — | | | |
| 0.063 | +/-0.010 | 0.064 | — | | | |
| 0.125 | +/-0.010 | 0.130 | — | | | |
| 0.875 | +/-0.010 | 0.880 | — | | | |
| 0.062 | +/-0.010 | 0.060 | — | | | |
| R0.03 | +/-0.030 | R0.030 | — | | | |
| R0.13 | +/-0.030 | R0.130 | — | | | |
| 1.00 | +/-0.030 | 1.007 | — | | | |
| 0.125 | +/-0.010 | 0.127 | — | | | |
| | | | | | | |
| 0.600 | +/-0.010 | 0.598 | — | | | |
| 4.000 | +/-0.005 | 3.999 | — | | | |
| 0.750 | +/-0.010 | 0.752 | — | | | |
| Ø0.194 | +0.005/-0.000 | Ø0.194 | — | | | |
| | | | | | | |
| 5.50 | +/-0.030 | 5.507 | — | | | |
| 0.125 | +/-0.010 | 0.128 | — | | | |
| 0.063 | +/-0.010 | 0.067 | — | | | |
| R0.25 | +/-0.030 | R0.25 | — | | | |
| 4.27 | +/-0.030 | 4.277 | — | | | |
| R0.30 | +/-0.030 | R0.30 | — | | | |
| | | | | | | |

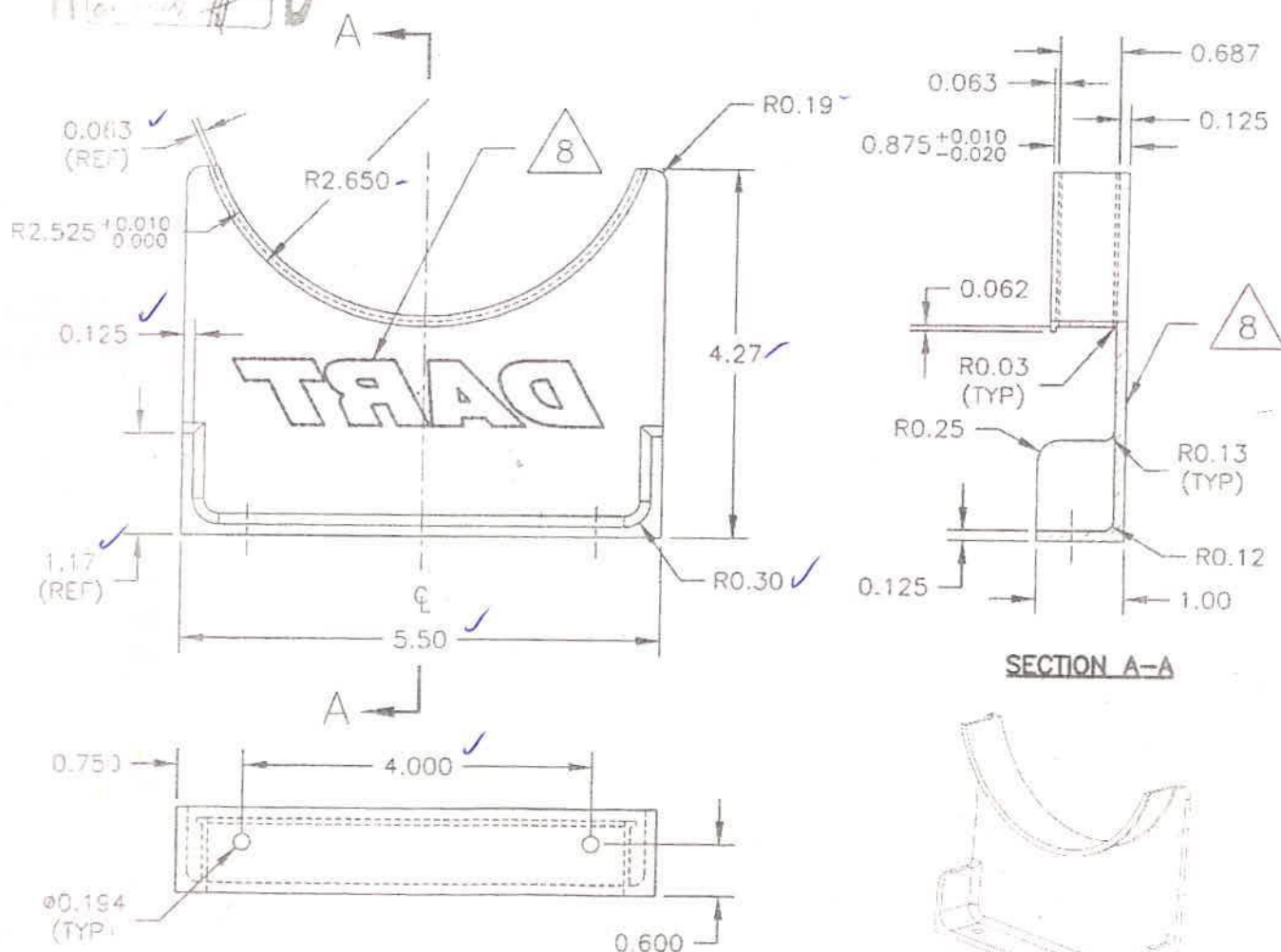
| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | JMK | Audited by: | JL | Prototype Approval: | N/A |
| Date: | 07/08/24 | Date: | 07/08/24 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------------|------------|----------|
| A | 04.09.03 | New Issue | KJ/JLM | |
| B | 05.04.26 | Ø0.194 was Ø0.208; dimensions removed | KJ/JLM | |



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN KT | DRAWN BY KT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED JH | APPROVED JH | DRAWING NO. D3264 | REV. A SHEET 1 OF 1 |
| DATE 04.04.20 | | TITLE BRACKET | SCALE 1:2 |
| A | 04.04.20 | NEW ISSUE | |

RELEASED



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

UNCONTROLLED
SUBMIT FOR REVIEW
WITHOUT NOTICE
WORK ORDER
NO. 33066


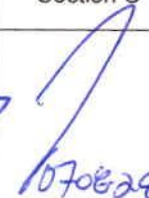
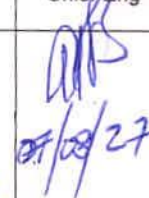
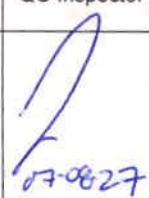

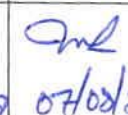

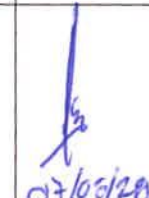

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|---|--|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/08/27 | 3.0 | 1 part scrap. The .125" thickness is .105". R.C. Operator placed part slightly crooked, resulting in most of the facing being too thin. |  07/08/27 | Part is scrap. destroy it , No replace | J.F. 07/08/27 |  07/08/28 |  07/08/27 |  07/08/27 |
| 07/08/27 | 3.0 | the dim. 0.600" are .580". |  07/08/28 | Deviation is Acceptable As holes are being transitioned from D3264-1 to A/C UPAW INSTALL. EDGE DISTANCE $\geq 2d$ |  07/08/28 |  07/08/28 |  07/08/28 |  07/08/28 |
| | | | | | | | | |

NOTE: Date & initial all entries